

Work Order ID 146267

Monday, May 16, 2016 10:30:40 AM

146267

Page 1

Item ID: D3802-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Windows Seal (\$ Per Foot)

Stop ***NS2***

Start Date: 5/19/2016 Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: MAY 18 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date: MAY 18 2016

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3802	D								
100	PURCHASING	0.00							DAS 13 9-89
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>32396</u>								
	Purchase Part Number: 93695K58								
	Supplier: Mc MASTER-CARR								
	Certificate of conformity is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	1.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D3802								

50 MAY 17 2016

50^F 5016-55-18

50

MAY 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Work Order ID 146267

Monday, May 16, 2016 10:30:40 AM

146267

Page 2

Item ID: D3802-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Windows Seal (\$ Per Foot)

Stop ***NS2***

Start Date: 5/19/2016 Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>416</i>	0.00						<i>Das</i>	
130								<i>6</i>	
Packaging	Memo	0.50				<i>50 feet</i>		<i>8-00</i>	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	5.00							
Quality Control									

MAY 24 2016

16/5/24/9

ML5 MAY 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
				OTHER : ☐					

Picklist Print

Monday, May 16, 2016 10:30:44 AM

Page 1

Work Order ID: 146267

146267

Parent Item: D3802-1

D3802-1

Parent Item Name: Windows Seal (\$ Per Foot)

Start Date: 5/19/2016

Required Date: 5/24/2016

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A 09-01-12 rev.A as per dwg DD verified by:ec
IPP Rev:B 09-04-15 rev.b as per dwg DD verified by:EC IPP Rev:C
10.08.04 p/n chg per ECN10-568 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

93695K58

Purchased

No

110

f

0.0000

1

50

93695K58

**

WINDOW SEAL

50^P 5/16-05-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

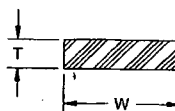
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

SPECIFICATION CONTROL DRAWING



D3802-X-YYY WINDOW SEAL WHERE YYY REPRESENTS LENGTH

DART P/N	SUPPLIER	SUPPLIER P/N	T THICKNESS	W WIDTH
D3802-1-YYY	McMASTER-CARR	93695K58	0.25	1.00

EG: 0.25" X 1.00" X 40" WINDOW SEAL = D3802-1-040
0.25" X 1.00" X 120" WINDOW SEAL = D3802-1-120

SEAL COPY
FOR USE TO
CHECKING
CONTROLLED COPY
NOT FOR RE-USE
NOTICE
WORK ORDER

146263 MJS

16-05-16

RELEASED
2011-11-25

NOTES:

- 1) MATERIAL: 'PEEL AND STICK' NEOPRENE/EPT/SBR BLEND CLOSED CELL SPONGE, MEDIUM DENSITY
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

D	CORRECTED P/N EXAMPLE FOR CUT LENGTH OF 40". ADDED EXAMPLE FOR CUT LENGTH OF 120" (2N B3-1). REASON: PAR11-100.	MB	11.11.22
C	CHANGE SUPPLIER P/N TO 93695K58 PER FLAMMABILITY TEST RESULTS	MB	10.08.30
B	CHANGE SUPPLIER P/N TO 93695K88 PER FLAMMABILITY TEST RESULTS	MB	08.12.16
A	NEW ISSUE	MB	08.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN	EA		
DRAWN			
CHECKED	JW		
MFG. APPR.	JW		
APPROVED	JW		
DE APPR.	JW		
DATE	11.11.22		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3802 TITLE WINDOW SEAL REV. D SHEET 1 OF 1 SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32396**

Purchase Order Date 5/17/2016

PO Print Date 5/17/2016

Page Number 7 of 9

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To :

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Total: \$37.00

Deliver To: LUC

20 71400-30

4457K85 2" PIPE 72"

5/19/2016

1.00

\$75.42

\$75.42

Yes

Each

5/19/2016

Line Total: \$75.42

Deliver To: LUC

21 71400-30

44615K417 1-1/4 PIPE

5/19/2016

1.00

\$2.02

\$2.02

Yes

Each

5/19/2016

Line Total: \$2.02

Deliver To: LUC

22 93695K58

WINDOW SEAL

5/19/2016

50.00

\$0.29

\$14.72

Yes

f

5/19/2016

AS PER DWG D3802 REV. D
B142267
C OF C REQUIRED

82/6-05-18

Note:

5/17/2016

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO32396

Order Placed By
Chantal Lavoie

McMaster-Carr Number
3429436-04

Page 1 of 2

05/17/2016

Line	Product	Ordered	Shipped
1	8705A64 DeWalt DWE4214 Electric Angle, Grinder for Grinding Wheels and Sanding Discs	1 Each	1
2	4125A186 Band Saw Blade for Straight Cuts, 1/2" WD X 0.025" Thickness, 140" LG, 14 Teeth Per Inch	6 Each	6
3	7965K38 Multipurpose Sleeve Bearing with Groove, for 1" Shaft Diameter, 1-3/8" OD, 1" LG.	2 Each	2
4	5906K412 Oil-Embedded Thrust Bearing, for 1" Shaft Diameter, 1-1/2" OD, 1/16" Thickness.	2 Each	2
5	8946A39 Tapered Carbide End Mill, 3 Flute, 1 Degree Taper, 1/4" Tip Diameter, 2" L of Cut	2 Each	1
6	4708K55 Bronze Check Valve, High Flow, 1 NPT Female, Class 125	1 Each	1
7	4708K58 Bronze Check Valve, High Flow, 2 NPT Female, Class 125	1 Each	1
8	44605K278 Low-Pressure Black Malleable Iron Thread Fitting, 1 X 1/2 Pipe Size, Reducing Coupling	1 Each	1
9	5259T5 Load-Center Circuit Breaker, Siemens Qp Series, Double Pole, 120/240 VAC, 30 Amps	1 Each	1
10	44615K424 Standard-Wall Black Steel Threaded Pipe Nipple, 1/2 Pipe Size X 1-1/2" Length	1 Each	1
11	47865K25 Brass Ball Valve, 1" NPT Female Connections	1 Each	1
12	44615K436 Standard-Wall Black Steel Threaded Pipe Nipple, 1 Pipe Size X 2" Length	3 Each	3
14	44615K546 Standard-Wall Black Steel Threaded Pipe Nipple, 1 Pipe Size X 12" Length	1 Each	1
15	4457K116 Standard Wall Black Welded Steel Pipe, 1 Pipe Size X 18" Length, Threaded Ends	1 Each	1
16	44605K116 Low-Pressure Black Malleable Iron Thread Fitting, 1 Pipe Size, 90 Degree Elbow	3 Each	3
17	44605K196 Low-Pressure Black Malleable Iron Thread Fitting, 1 Pipe Size, Union	1 Each	1
18	44615K319 Standard-Wall Black Steel Threaded Pipe Nipple, 2 Pipe Size X 9" Length	1 Each	1
21	44615K417 Standard-Wall Black Steel Threaded Pipe Nipple, 1-1/4 Pipe Size X 1-5/8" Length, Fully Threaded	1 Each	1
22	93695K58 Oil-Rst Fire-Retardant Blended Buna-N Foam, 50 ft. Adhesive-Back Strip, 1/4" Thickness, 1" WD	1 Each	1

801605-18

Packing List

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO32396

Order Placed By
Chantal Lavoie

McMaster-Carr Number
3429436-04

Page 2 of 2

05/17/2016

Line	Product	Ordered	Shipped
23	97395A451 Corrosion Resistant Dowel Pin, Type 316 Stainless Steel, 1/8" Diameter, 3/4" Length, Packs of 10	5 Packs	5
24	30345T552 18-8 Stainless Steel Wire Rope Lanyard - Not for Lifting, Loop-to-Tab, 3/64" Rope Diameter, 12" LG, Nylon	10 Each	10

Shipped separately from our Chicago warehouse on 05/17

5	8946A39 Tapered Carbide End Mill, 3 Flute, 1 Degree Taper, 1/4" Tip Diameter, 2" L of Cut	2 Each	1
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Sp/6-05-18